

Work Order ID 58651

May 13, 2010 7:25:24 AM



Page 1

Item ID: D412-742-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Skidtube Installation

Start Date: 5/13/10 Start Qty: 1.00



Cust Item ID:

Required Date: 5/17/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-742

D

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels per PPP D412-742-013 CHG006

8/10/13

HJ for BG 10/05/13

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

10-5-14

120

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

8/10/13

FL

Work Order ID 58651

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Page 2

Item ID: D412-742-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Skidtube Installation

Start Date: 5/13/10 Start Qty: 1.00



Cust Item ID:

Required Date: 5/17/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-742-013

Location:

MEH

4/10/13 (1)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/01

ME
10-6-01

BE8380

Picklist Print

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Page 1

Work Order ID: 58651

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 5/13/10

Required Date: 5/17/10

Comments: IPP Rev: A: 105.10.13: [New Issue] KJ/JLM
IPP Rev: B: 06-06-08 As per DS19336 JLM IPP RevC 07-12-03 ECN
1072 DD verified by: JLM
IPP Rev: D: 08-09-08 ecn 08-510 DD verified by: EC

Start Qty: 1.00

Required Qty: 1.00

AN4C7A
Bolt

Purchased No 110 Each 484.0000



4 10-5-14 sl

Location Loc Qty Loc Code

ST356 484
109147 484

D412-742-043
Replacement Float Skidtube
D2571

Manufactured No 110 Each 0.0000



5 5832

6142/310

Manufactured No 110 Each 16.0000



105+14 sl

Saddle, Fwd Out 205

Location Loc Qty Loc Code

ST425 8
43564 4
47564 4

ST433 8
58250 8

D2572
Saddle, Fwd In 205

Manufactured No 110 Each 12.0000



10-5-14 sl

Location Loc Qty Loc Code

ST425 4
43565 4

ST433 8
58100 8

Picklist Print

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Page 2

Work Order ID: 58651

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Comments: IPP Rev: A: 05.10.13 New Issue KJ/JLM:
IPP Rev: B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN
1072 DD verified by: JLM
IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Date: 5/13/10

Required Date: 5/17/10

Start Qty: 1.00

Required Qty: 1.00

D2573
Saddle, Aft Out 205

Manufactured No 110 Each 8.0000

Location	Loc Qty	Loc Code
ST425	8	
43566	4	
47566	4	

D2574
Saddle, Aft In 205

Manufactured No 110 Each 4.0000

Location	Loc Qty	Loc Code
ST425	4	
43567	4	

D2876
Saddle Spacer

Manufactured No 110 Each 93.0000

Location	Loc Qty	Loc Code
ST028	93	
42364	46	
51540	47	

D2877
Saddle Spacer

Manufactured No 110 Each 25.0000

Location	Loc Qty	Loc Code
ST028	25	
51541	25	

358251 10-5-208

358252 10-5-208

10-5-14sl

10-5-14-sl

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Picklist Print

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Page 3

Work Order ID: 58651

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 5/13/10

Required Date: 5/17/10

Comments: IPP Rev: A 05.10.13 (New Issue) KJ/JLM: 1
IPP Rev: B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN
1072 DD verified by: JLM
IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Qty: 1.00

Required Qty: 1.00

D3403-1
Bushing

Manufactured No 110 Each 60.0000



16 10-5-14 SL

Location	Loc Qty	Loc Code
ST055	60	
56856	60	

D2747
Set Screw

Manufactured No 110 Each 113.0000



16 10-5-14 SL

Location	Loc Qty	Loc Code
ST023	113	
39224	4	
51921	109	

D3533-1
Set Screw

Manufactured No 110 Each 123.0000



2 10-5-14 SL

Location	Loc Qty	Loc Code
ST069	123	
51602	123	

AN4C6A
Bolt

Purchased No 110 Each 439.0000



16 10-5-14 SL

Location	Loc Qty	Loc Code
FG	4	
103344	4	
ST356	435	
113121	435	

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Shop Packet Print

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Picklist Print

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Page 4

Work Order ID: 58651

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 5/13/10

Required Date: 5/17/10

Comments: IPP Rev: A 105.10.13 New Issue: KJ/JLM
IPP Rev: B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN
1072 DD verified by: JLM
IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Qty: 1.00

Required Qty: 1.00

AN4C52A Purchased No 110 Each 126.0000 8
BOLT

Location Loc Qty Loc Code

ST361 126
112641 50
113121 76

AN6C12A Purchased No 110 Each 104.0000 8
BOLT

Location Loc Qty Loc Code

ST342 104
110396 54
114442 50

D3672-3 Manufactured No 110 Each 1,236.000 32
Phenolic Washer

Location Loc Qty Loc Code

ST077 1236
51596 6
55560 290
57704 940

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Shop Packet Print

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Picklist Print

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Page 5

Work Order ID: 58651

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 5/13/10

Required Date: 5/17/10

Comments: IPP Rev: A: 05.10.13: New Issue: KJ/JLM:
IPP Rev: B: 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN
1072 DD verified by: JLM
IPP Rev: D: 08-09-08 ecn 08-510 DD verified by: EC

Start Qty: 1.00

Required Qty: 1.00

AN960C416L

Purchased

No

110

Each

1,068.000

32

WASHER

Location

Loc Qty

Loc Code

FG

44

104925

44

ST346

1024

112612

124

112794

500

112828

400

D3672-9

Manufactured

No

110

Each

446.0000

8

Phenolic Washer

Location

Loc Qty

Loc Code

ST077

446

35523

446

AN960C616L

Purchased

No

110

Each

212.0000

8

WASHER

Location

Loc Qty

Loc Code

ST347

212

111424

12

113064

200

D3672-11

Manufactured

No

110

Each

968.0000

16

Phenolic Washer

Location

Loc Qty

Loc Code

ST077

968

58046

968

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Shop Packet Print

Page 5

Picklist Print

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Work Order ID: 58651

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Comments: IPP Rev: A 05.10.13 New Issue: KJ/JLM
 IPP Rev: B 06-06-08 As per DS19336 JLM IPP Rev C 07-12-03 ECN 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Date: 5/13/10

Required Date: 5/17/10

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,438.000

29



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1398

112492

25

113069

8

114181

365

114348

500

114523

500

29

D3403-3

Manufactured

No

110

Each

53.0000

8



Bushing

Location

Loc Qty

Loc Code

ST055

53

56857

53

110

Each

16.0000

1

D3405-041

Manufactured

No



Lug Assembly

Location

Loc Qty

Loc Code

ST474

16

56835

4

57726

12

Picklist Print

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Work Order ID: 58651

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Comments: IPP Rev: A 05-10-13 New Issue KJ/JLM
 IPP Rev: B 06-06-08 As per DSI9336 JLM IPP Rev: C 07-12-03 ECN 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Date: 5/13/10

Required Date: 5/17/10

Start Qty: 1.00

Required Qty: 1.00

D3405-043

Manufactured No

110

Each

18.0000



Lug Assembly

Location

Loc Qty

Loc Code

ST474

18

53888

1

56574

3

57727

14

AN4C47A

Purchased

No

110

Each

100.0000



Bolt

Location

Loc Qty

Loc Code

ST361

100

114653

100

D3407-041

Manufactured

No

110

Each

0.0000



Tow Ring

D3417-3

Manufactured

No

110

Each

122.0000



Washer

Location

Loc Qty

Loc Code

ST056

122

44349

41

51648

28

53182

53

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Shop Packet Print

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Picklist Print

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Page 8

Work Order ID: 58651

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 5/13/10

Required Date: 5/17/10

Comments: IPP Rev: A 05.10.13 New Issue KJ/JLM
 IPP Rev: B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110 Each

137.0000



Washer



10-5-14 SL

Location

Loc Qty

Loc Code

ST058

137

51653

4

54692

133

AN3C37A

Purchased No

110 Each

58.0000



BOLT



10-5-14 SL

Location

Loc Qty

Loc Code

ST353

58

112454

58

AN3C40A

Purchased No

110 Each

125.0000



BOLT



10-5-14 SL

Location

Loc Qty

Loc Code

ST354

125

106176

25

112454

50

114442

50

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Shop Packet Print

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Picklist Print

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Page 9

Work Order ID: 58651

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 5/13/10

Required Date: 5/17/10

Comments: IPP Rev: A 05.10.13 New Issue KJ/JLM
 IPP Rev: B 06-06-08 As per DSI9336 JLM IPP Rev: C 07-12-03 ECN 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Qty: 1.00

Required Qty: 1.00

AN3C41A

Purchased

No

110

Each

223.0000



BOLT



10-5-1451

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

219

112431

19

112829

100

114443

100

AN3C42A

Purchased

No

110

Each

124.0000



BOLT



10-5-1461

Location

Loc Qty

Loc Code

ST354

124

106169

24

106176

100

AN3C43A

Purchased

No

110

Each

141.0000



BOLT



10-5-1452

Location

Loc Qty

Loc Code

ST354

141

114330

41

114433

50

114455

50

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Shop Packet Print

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Picklist Print

May 13, 2010 7:25:17 AM

Work Order ID: 58651

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 5/13/10

Required Date: 5/17/10

Comments: IPP Rev: A1105.10.13: (New Issue) KJ/JLM:1
 IPP Rev: B 06-06-08 As per DS19336 JLM IPP RevC 07-12-03 ECN
 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC

Start Qty: 1.00

Required Qty: 1.00

AN3C46A Purchased No 110 Each 46.0000
 BOLT

5 10-5-14

Location Loc Qty Loc Code

ST355 46
 113164 3
 113302 43

AN960C10L Purchased No 110 Each 0.0000
 washer
 MS21043-3

26 1114341 10-5-14

Nut Purchased No 110 Each 3.635.000
 13

10-5-14

Location Loc Qty Loc Code

FG 80
 103691 80
 ST301 3555
 112314 3555

13

5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

Item	Qty -013	Qty -043	Part Number	Description
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE
		1	D3391-043	412 FLOAT SKIDTUBE
1		*24	*AN3C4A	*BOLT
3		*12	*AN3C6A	*BOLT
4		*8	*AN3C7A	*BOLT
		*44	*AN960C10L	*WASHER
21A		*1	*D3564-1	*WEARSHOE (REPLACES D3450-1)
21B		*1	*D3566-1	*GASKET
22A		*1	*D3564-3	*WEARSHOE (REPLACES D3450-3)
22B		*1	*D3566-1	*GASKET
23A		*1	*D3564-5	*WEARSHOE (REPLACES D2577-5)
23B		*1	*D3566-5	*GASKET
10		*1	*D3391-021	*412 FORWARD TUBE
11		**1	**D3401-041	**TOW CAP
12A		**10	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
12B		**2	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB166)
13		**10	**AN3C4A	**BOLT
14A		**4	**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10	**AN960C10L	**WASHER
24A		**1	**D3564-13	**WEARSHOE
24B		**1	**D3566-13	**GASKET
20		*1	*D3391-023	*412 MID TUBE
21		**20	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		*1	*D3391-025	*412 AFT TUBE
25A		**1	*D3537-1	**WEARPAD
25B		**1	*D3553-1	**GASKET
26A		**1	*D3537-7	**WEARPAD
26B		**1	*D3553-3	**GASKET
31		**1	**D2646	**AFT CAP
32		**14	**AELS-1032-130	**INSERT
33		**12	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6	**AN3C4A	**BOLT
37B		**4	**AN3C5A	**BOLT
38A		**2	**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10	**AN960C10L	**WASHER

(CONTINUED ON PAGE 19)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE

DART AEROSPACE USA, INC.

IIN-D412-742

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(CONTINUED FROM PAGE 18)

Item	Qty -013	Qty -043	Part Number	Description
40	1		D2571	SADDLE, FWD OUTSIDE
41	1		D2572	SADDLE, FWD INSIDE
42	1		D2573	SADDLE, AFT OUTSIDE
43	1		D2574	SADDLE, AFT INSIDE
44	2		D2876	SADDLE SPACER
45	2		D2877	SADDLE SPACER
46	13		D3403-1	BUSHING
47A	4		D2747	SET SCREW
47B	2		D3533-1	SET SCREW
48	15		AN4C6A	BOLT
49	8		AN4C52A	BOLT
50	8		AN6C12A	BOLT
51A	32		D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32		AN960C416L	WASHER
52A	8		D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8		AN960C616L	WASHER
53	15		D3672-11	WASHER (REPLACES NAS1515H7L)
54	24		MS21043-4	NUT
55	4		ANC47A	BOLT
59	8		D3403-3	BUSHING
61	1		D3405-041	GHW LUG
62	1		D3405-043	GHW LUG
63	4		AN4C46A	BOLT
64	4		MS21043-4	NUT
66	1		D3407-041	TOW RING
67	2		D3417-3	WASHER
68	1		MS21043-4	NUT
73	1		D3456-1	WASHER
81	1		AN3C37A	BOLT
82	1		AN3C40A	BOLT
83	1		AN3C41A	BOLT
84	4		AN3C42A	BOLT
85	4		AN3C43A	BOLT
87	5		AN3C46A	BOLT
88	26		AN960C10L	WASHER
100	13		MS21043-3	NUT

* DENOTES PART IS INCLUDED WITH D3391-043 ASSEMBLY ABOVE

** DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: D

Date: 07.10.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3.

REF. FAA STC: SR01583SE
REF. CANADIAN STC: SH05-37
REF. EASA STC: EASA.IM.R.S.01126

REFERENCE ONLY

INSTRUCTIONS:

- 1) FOR D412-742-011/-013 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, UPDATE THE PARTS LIST TO MODIFY THE BOLT USED TO ATTACH THE GHW LUG AS FOLLOWS:

5.1 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

32.15 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

ITEM	Qty -011	Qty -041	Qty -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
		X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

IS:

63	4			AN4C47A	BOLT
----	---	--	--	---------	------

WAS:

63	4			AN4C46A	BOLT
----	---	--	--	---------	------

5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

32.15 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

ITEM	Qty -013	Qty -043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
		X	D412-742-043	FLOAT SKIDTUBE

IS:

63	4			AN4C47A	BOLT
----	---	--	--	---------	------

WAS:

63	4			AN4C46A	BOLT
----	---	--	--	---------	------

A	NEW ISSUE	AJS	08.12.19
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT MADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9441	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BOLT CHANGE	NTS
DATE	08.12.19	COPYRIGHT © 2003 BY DART AEROSPACE USA, INC	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries